

Date: Monday, 5/26/2008 1:09:52 PM  
User: Chantal Lavoie

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: PANEL-350 AFT CANOPY
<b>Job Number</b>	: 39497		
<b>Estimate Number</b>	: 13098		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D36561
<b>This Issue</b>	: 5/26/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3656 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: 00204
<b>Previous Run</b>	: 39494	<b>Drawing Revision</b>	: A
	<b>Type</b>	<b>Material</b>	:
	: THERMOFORMING	<b>Due Date</b>	: 5/30/2008
<b>Written By</b>	:	<b>Qty:</b>	4
<b>Checked &amp; Approved By</b>	: <u>JUP 08.5.26</u>	<b>Um:</b>	Each
<b>Comment</b>	: Est. Rev. A 07/12/13 DL verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
<b>Comment:</b> Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s) GE PLASTICS LEXAN SHEET batch: <u>105494</u>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
<b>Comment:</b> HAND FINISHING THERMOFORMING 1) Cut Blanks to fit frame size <div style="float: right;">BB 08/06/12 XY</div>		
3.0	THERMOFORMING	THERMOFORMING MACHINE
<b>Comment:</b> THERMOFORMING MACHINE Thermoform as per Dwg. D3656-1and Folio FTA 015 using tool DT 8986 Dwg. Rev. <u><del>A</del></u> Folio Rev. <u><del>A</del></u> <div style="float: right;">BB 08/06/13 XY</div>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE Visually inspect for proper formation of each part <div style="float: right;">BB 08/06/13 XY</div>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 28/06/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 39497		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.12	3	2 parts did not form properly dirt in machine RC: Peter house keepin' needed	JB 08/06/12	Scrap & replace parts clean infrared eye.	JB 08/06/12	JB 08/06/20	JB 08/06/12	JB 08/06/20
08.06.12	3	2 parts not formed. Too much moisture in sheet.	JB 08/06/12	Scrap & replace parts. dry sheets prior to using.	JB 08/06/12	JB 08/06/20	JB 08/06/12	JB 08/06/20
		RC: new development						

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 39497

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8 08/06/12 (24)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

BB 08/06/16

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 08/06/16

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/06/12 (24)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 39941

8/6/19 SCD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/2398

Job Completion



MF 08-06-20

**Dart Aerospace Ltd**

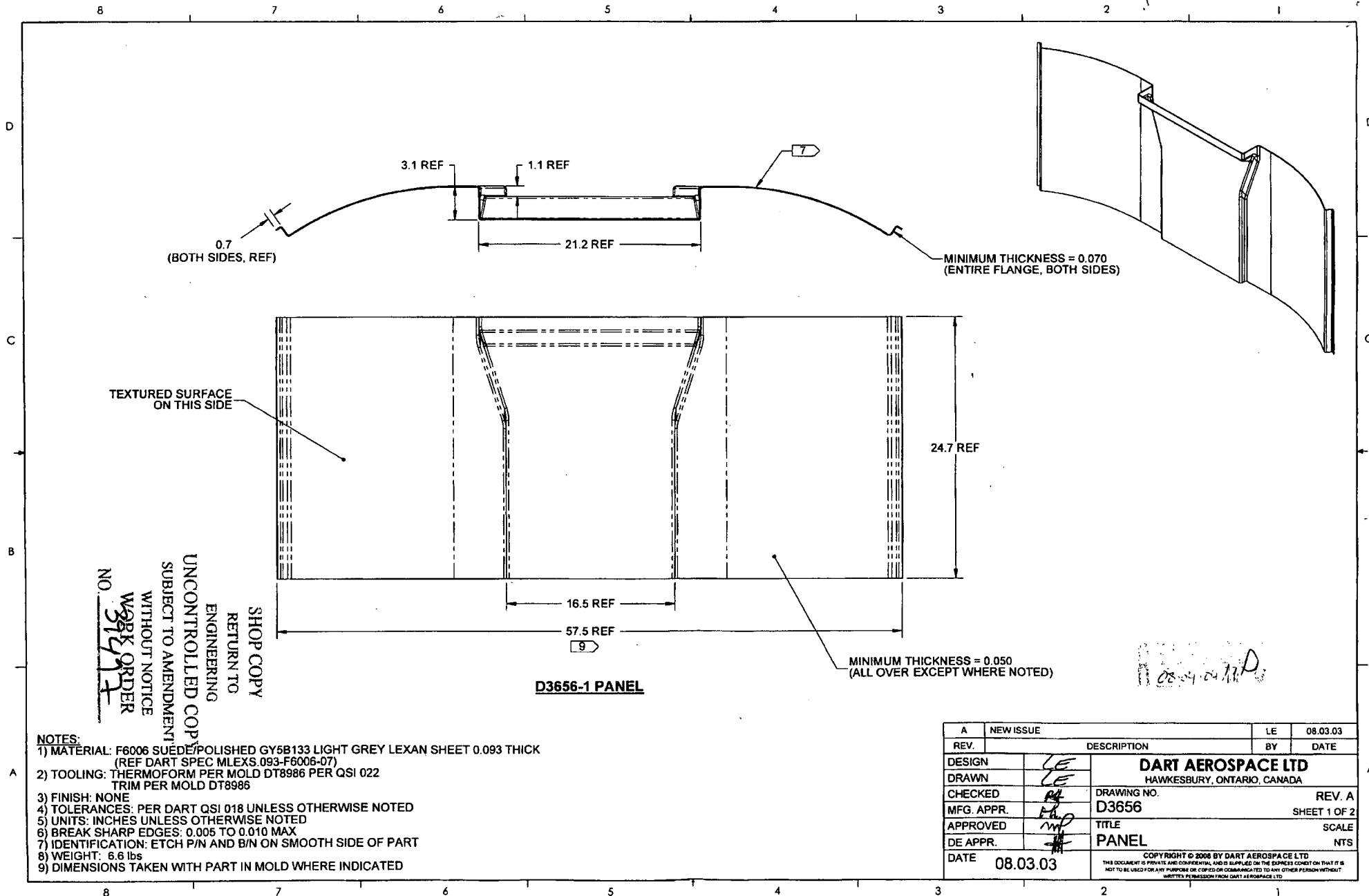
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

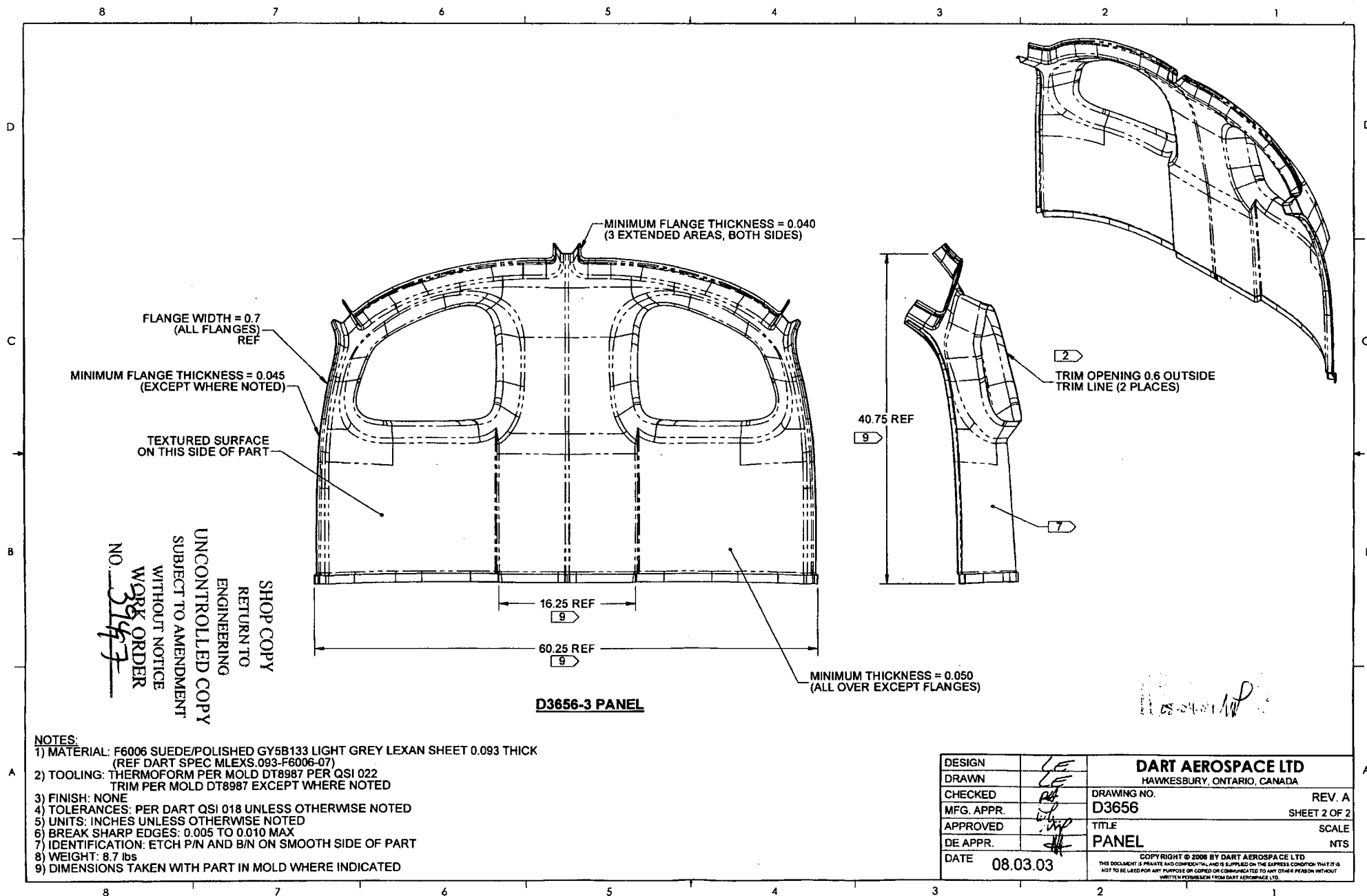
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER MOLD DT8987 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	CE	<b>DART AEROSPACE LTD</b>	
DRAWN	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D3656	SHEET 2 OF 2
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	PANEL	NTS
DATE	08.03.03	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		WORK ORDER: 38457
Description: Aft Canoy		Part Number: D3656-1-1
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7"	0.100"	24.7	✓			
57.5"	0.100"	57.5	✓			
21.2"	0.100"	21.2	✓			
0.7" Flange length	.030"	.65	✓			
0.70" Thickness	Min	.73	✓			

Measured by: BB	Audited by: S	Prototype Approval: 1/1
Date: 08/06/16	Date: 08/06/17	Date: 1/1

Rev	Date	Change	Revised by	Appro
		New Issue		

DART AEROSPACE LTD		WORK ORDER: 39487
Description: Aft Canoy		Part Number: 1 D3656
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7"	0.100"	24.76	✓			
57.5"	0.100"	57.5	✓			
21.2"	0.100"	21.25	✓			
0.7" Flange length	.030"	.7	✓			
0.70" Thickness	Min	.71	✓			

Measured by: BB
Date: 08/06/16

Audited by: S
Date: 08/06/17

Prototype Approval: 1/2
Date: 1/2

Rev	Date	Change	Revised by	Appro
		New Issue		



DART AEROSPACE LTD		WORK ORDER:	39497
Description: Aft Canoy		Part Number:	2. D3656-
Inspection Dwg:	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7"	0.100"	24.7	✓			
57.5"	0.100"	57.5	✓			
21.2"	0.100"	21.25	✓			
0.7" Flange length	.030"	.7	✓			
0.70" Thickness	Min	.76	✓			

Measured by: BB	Audited by: S	Prototype Approval: 1/12
Date: 08/06/16	Date: 08/06/17	Date: 1/12

Rev	Date	Change	Revised by	Appro
		New Issue		

DART AEROSPACE LTD		WORK ORDER: 39497	
Description: Aft Canoy		Part Number: 3 D3656	-1
Inspection Dwg:	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.7"	0.100"	24.76	✓			
57.5"	0.100"	57.5	✓			
21.2"	0.100"	21.25	✓			
0.7" Flange length	.030"	.75	✓			
0.70" Thickness	Min	.78	✓			

Measured by: BD	Audited by: S	Prototype Approval: u/b
Date: 08/06/16	Date: 08/06/17	Date: 10/6

Rev	Date	Change	Revised by	Appro
		New Issue		